

19-7795



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-351
Job Sheet 201545



Part No: D206-642-351

Job Qty: 1 pcs

Part Name: Replacement Skidtubes, Low & High Gear, Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4361-041 REV A, IIN-D206-642 REV Q SHEETS 29-30 IPP REV:A NEW ISSUE 12-07-09 JLM
VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/30/19		0.00	3.26	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		TF
							Skidtubes - 6		FE
							Skidtubes - 7		
112	QC 9	1 pcs	10/30/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		EC
115	QC 5	1 pcs	10/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		



Container No: S228445



Part: D206-642-351

Job No: 201545

Serial No/Batch: S228445

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/30/19

Plex 10/7/19 10:33 AM Dart.lajeunesse.ma

P.T.O.

10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120	Handfinish - 1-1 Chemical-B4B	1 pcs	10/30/19	0.00 0.83	QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	OCT 31 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
125	QC 7	1 pcs	10/30/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	

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					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	ING
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
130	Skidtubes - 2 - B4B	1 pcs	10/30/19	0.00 3.26 55 min TF	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
140	QC 5	1 pcs	10/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Skidtubes - 2 - B4B	1 pcs	10/30/19	0.00 3.26	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
170	QC 10	1 pcs	10/30/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	
180	QC 5	1 pcs	10/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	

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					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS NOV 05 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190	Handfinish - 2-1 Pressure-B4B	1 pcs	10/30/19	0.00 0.50	Handfinish - 2 - 1 - B4B	BEB 19-11-06.
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
200	Powdercoat - 1 White GI(A)-B4B	1 pcs	10/30/19	0.00 0.23	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BR 19-11-8.
					Powdercoat - 4 - B4B	
210	QC 3	1 pcs	10/30/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	Jul 14-11-11
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
220	Handfinish - 4-1-Assembly-B4B	1 pcs	10/30/19	0.00 0.83	Handfinish - 4 - 1 - B4B	Jul 14-11-11
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	

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250	Packaging 3-1 - Stock - B4B	1 pcs	10/30/19	0.00 0.00	QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
255	DC - 1 - B4B	1 pcs	10/30/19	0.00 0.00	DC - 1 - B4B	DAS 21
					DC - 2 - B4B	21
260	QC 21 - FG	1 pcs	10/30/19	0.00 0.00	QC 21 - FG - 21	NOV 14 2019
					QC 21 - FG - 70	DAS 21
					QC 21 - SA - 53	NOV 14 2019

Part Op 110 - Skidtubes-2 (Skidtubes) 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg
 Descriptions: D4361 3-Weld Fwd Cap as per Dwg D4361 Use aluminum rod. Grind D2647 to fit as required. 5-Cut aft end to length as
 per dwg D4361 6-Drill pilot holes using drill Jig DT8168A and DT8168B and DT8025. Most Fwd wearplate hole to be laid
 out manually. 8-Open Aft Cap Hole using # Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-041
 Drilling Detail 10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D4361 11-Deburr and Blow out all chips
 form inside the tube

115 - QC5 (QC5- Inspect part completeness to step on W/O)

120 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

125 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

130 - Skidtubes-2 (Skidtubes) 1-Open holes to finished size as per Dwg D4361, D4361-041 Drilling Detail 2-Countersink
 crossbolt spacer holes as per Dwg D4361 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond
 D2654-5 web in place as per QSI 015, Ensure holes line up. Allow 12 Hrs. cure time

140 - QC5 (QC5- Inspect part completeness to step on W/O)

150 - Skidtubes-2 (Skidtubes) 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg
 D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 2-Grind welds flush
 as per Dwg D4361. 3-Counterbore 5/16" x 0.750" deep as per Dwg D4361. Deburr 4- Install nut plate as per dwg

170 - QC10 (QC10- Inspect visual per QSI004- ground welds)

180 - QC5 (QC5- Inspect part completeness to step on W/O)

190 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings)AND ALODINE ONLY AS PER
 QSI005

200 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint

screw, and mask GHW studs.

210 - QC3 (QC3- Inspect Part Finish)

220 - HandFinish4 (Assemble as per dwg) 1-Install wearplates as per dwg D4361. 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D4361. Clean excess adhesive 6-Wing Walk as per Dwg D4361-041 and QSI 005 4.4

230 - QC3 (QC3- Inspect Part Finish)

240 - QC5 (QC5- Inspect part completeness to step on W/O)

250 - Packaging3-1 (Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-351

255 - DC (Document Control) Photocopy bluefile and create labels per PPP D206-642-351 CHG001

260 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	5210317
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5166098
D2654-5	Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B	5220149
D2649	Cross Bolt Spacer	23 pcs (23 ea)	150-Skidtubes - 2 - B4B	5225932x20 5214176x3
AN3-36A	Bolt	9 Ea (9 ea)	220-Handfinish - 4-1-Assembly-B4B	5218142
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5699573
CR3212-4-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5163230-3
D2646	Aft Cap	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5197616
D2651-1	Plug	4 pcs (4 ea)	220-Handfinish - 4-1-Assembly-B4B	5196041
D2651-3	O-Ring	4 pcs (4 ea)	220-Handfinish - 4-1-Assembly-B4B	5180520
D2680-041	Nut Plate	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5197616
D3873-1	Bushing	18 pcs (18 ea)	220-Handfinish - 4-1-Assembly-B4B	5215511
D4364-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5229373
D4364-043	Run-on Landing Wearplate Aft	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5229412
MS21042-3	Nut use MS21042L3 per QSI 017	9 Ea (9 ea)	220-Handfinish - 4-1-Assembly-B4B	5162897
MS27039-1-08	Screw	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5166974-7
MS27039-4-06	Screw	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5211533
NAS1149C0332R	Washer (AN960C10L)	9 Ea (9 ea)	220-Handfinish - 4-1-Assembly-B4B	5218154
NAS1149D0332J	Washer	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5178379
NAS1149D0463J	Washer	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5158585

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	15	0
	D2647	1	20	0
130-Skidtubes - 2 - B4B	D2654-5	1	8	0
150-Skidtubes - 2 - B4B	D2649	23	51	0
220-Handfinish - 4-1-Assembly-B4B	AN3-36A	9	50	0
	CCR264SS3-3	2	43	0
	CR3212-4-3	2	232	0
	D2646	1	46	0
	D2651-1	4	205	0
	D2651-3	4	609	0
	D2680-041	1	21	0
	D3873-1	18	83	0
	D4364-041	1	0	0
	D4364-043	1	0	0
	MS21042-3	9	455	0
	MS27039-1-08	2	186	0
	MS27039-4-06	1	228	0
	NAS1149C0332R	9	4,028	0
	NAS1149D0332J	2	1,455	0
	NAS1149D0463J	1	2,589	0

Part Specifications

Specifications could not be found.

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-160	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

NOTES:

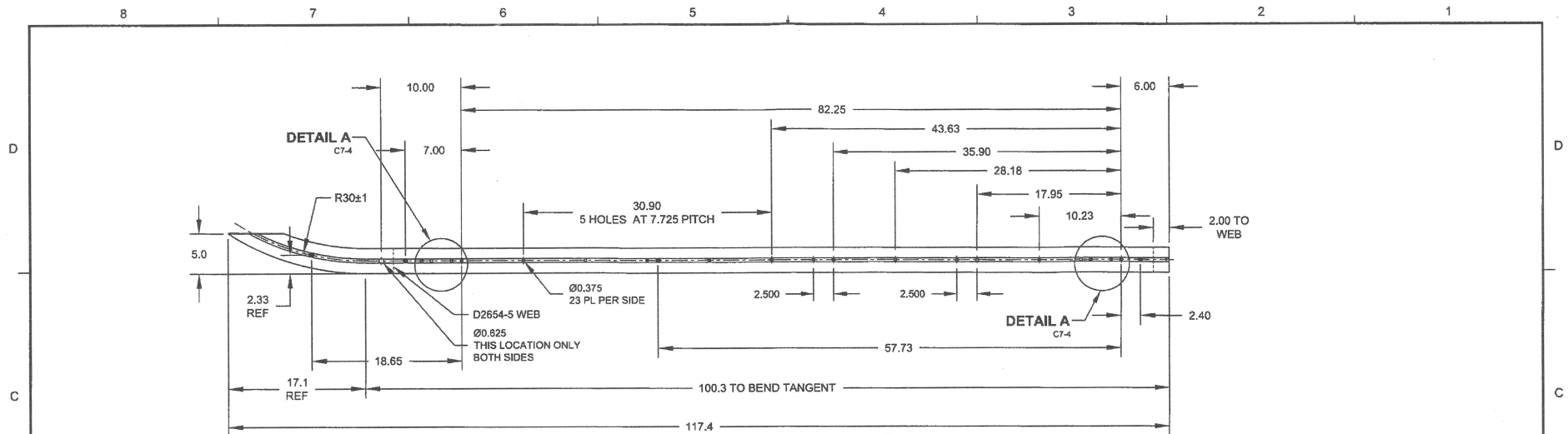
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

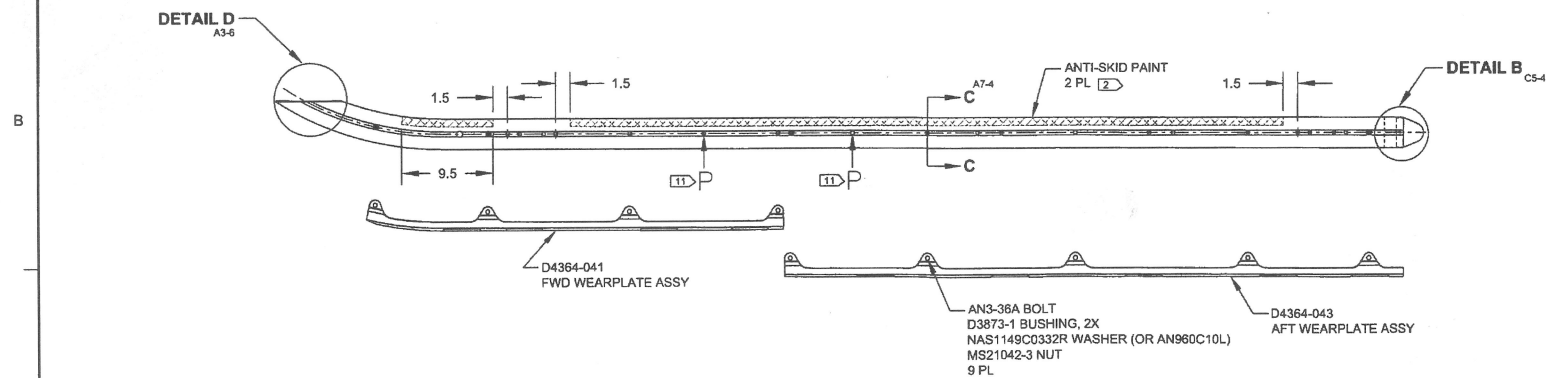
NO. 201545 MCL
19-10-07

RELEASED
2011-09-12

A	NEW ISSUE	SC	11.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	E	D4361	SHEET 1 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	H	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



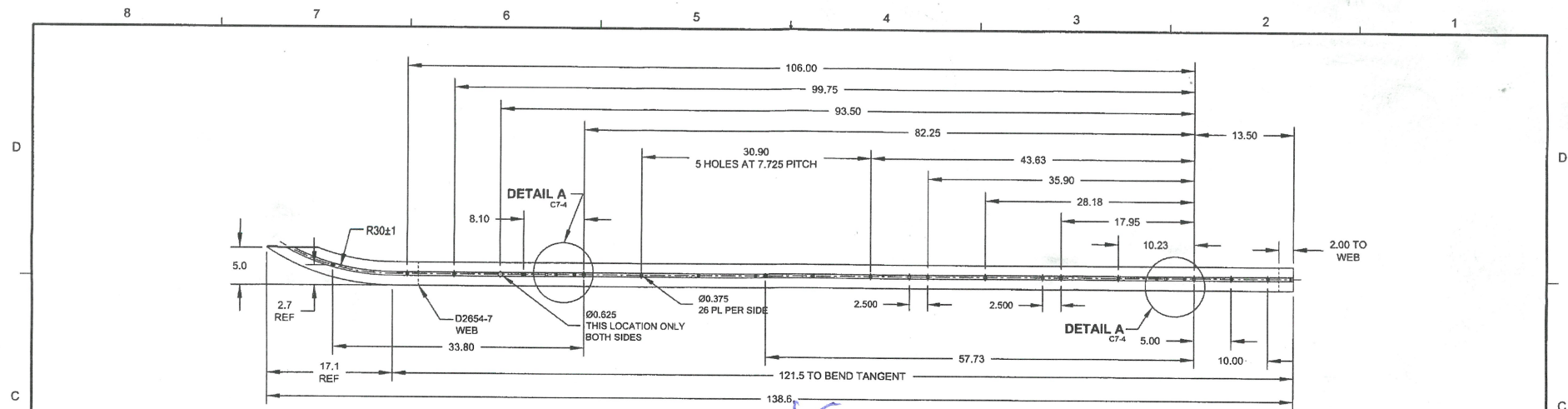
D4361-041 BENDING/DRILLING DETAIL



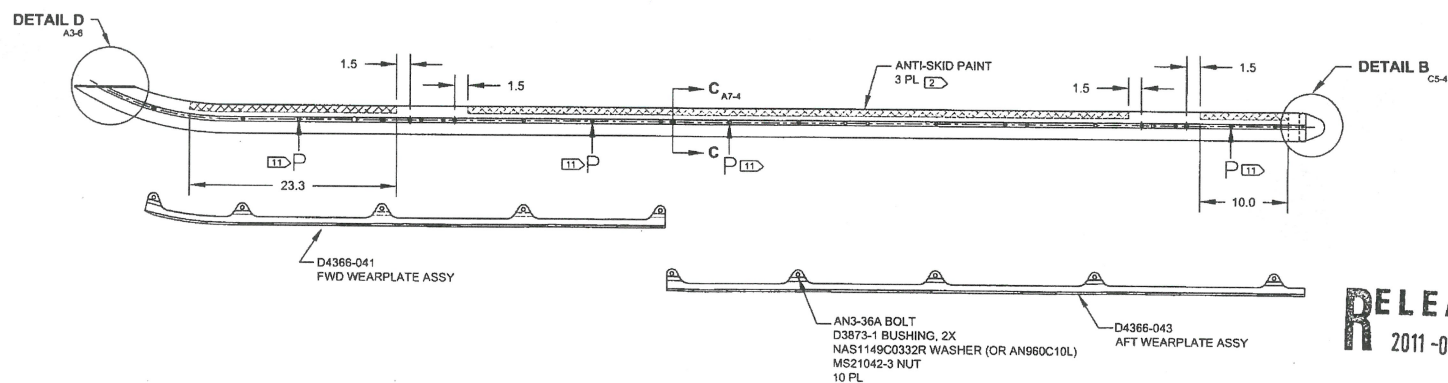
D4361-041 ASSEMBLY/FINISHING DETAIL

RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D4361	SHEET 2 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



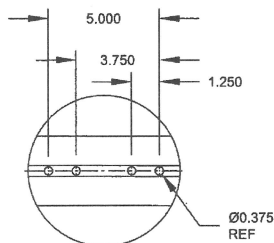
D4361-043 BENDING/DRILL DETAIL



D4361-043 ASSEMBLY/FINISHING DETAIL

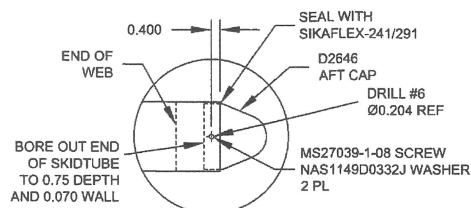
RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
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MFG. APPR.	<i>JP</i>	D4361	SHEET 3 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRINTED ON RECYCLED PAPER. NO OTHER INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	



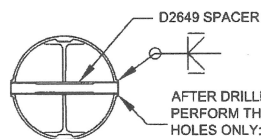
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

B2-2
B1-3



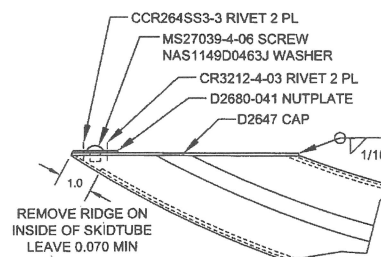
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

SECTION C-C

FOR Ø0.375 HOLES
ONLY

B4-2
B5-3

ORIENTATION OF
D2680-041



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4361	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered:

LR

Date:

Dec 31/19



NCR No.

19-7795

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>201545</u> Part No. <u>D206-642-357</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☐																															
Date: <u>19/10/30</u>		Sequence #: <u>120 130</u>		QTY Affected: <u>①</u>		MRB (QSI042) <u>12</u> <u>19/10/30</u>																													
Description Work Order Deviation				Disposition																															
Dwg calls for $\phi 0.625$ tow ring hole which is too small for tow ring				Drill tow ring hole $\phi 0.640$ Ref. D3274 Rev. G																															
								Completed By <u>19/10/30</u>																											
								Lead hand / Supervisor <u>19-10-30</u>																											
QC / QA Coordinator <u>19.11.29</u>																																			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☒ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☒ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☒ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☒ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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